

# Work Order ID 110034

December-17-13 9:06:39 AM

\*110034\*

RUSH

Page 1

Item ID: D3023-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Back Panel

Start Date: 12/19/13

Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 12/19/13

Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: H

Date: 12-17-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3023

Rev A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3023

Dwg Rev: A

Prog Rev: A

\*\*\*graind direction along 28.100" \*\*\*

2-Deburr if necessary

3

0

Ac

14-02-09

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

3

0

Ac

14-02-09

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**\*110034\***

Page 2

Item ID: D3023-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Back Panel  
 Start Date: 12/19/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 12/19/13 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 27 9-89 14/2/10				3			
130 <b>*130*</b> Brake NC Brake NC	Form as per dwg  Memo	0.00  0.00		DAS 30 9-89		3			14/02/10
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 DAS 27 9-89 14/2/10				3			

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\*110034\*

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Item ID: D3023-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Back Panel

Start Date: 12/19/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 12/19/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>W/A051</u>	0.00							
<b>*180*</b>						<u>3</u>	<u>2</u>	<u>14-271</u>	
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>								<u>MCS 14-02-11</u>	
QC	Memo	0.00							
Quality Control									

(H) 14-02-11

# Picklist Print

December-17-13 9:06:39 AM

Page 1

Work Order ID: 110034  
Parent Item: D3023-1  
Parent Item Name: Back Panel

Start Date: 12/19/13 Required Date: 12/19/13  
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP C02.01.23Revised NG  
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032 2024-T3 .032 sheet		Purchased	No			100	sf	409.0000	2.8777	4			

*Ac 14-22-13*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	409	
118523	2	
121309	17	
123574	12	
124987	6	
M127668	372	

127668

→ (4) (12)

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	110034
<b>Description: Back Panel</b>		<b>Part Number:</b>	D3023-1
<b>Inspection Dwg: D3023 Rev: A</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

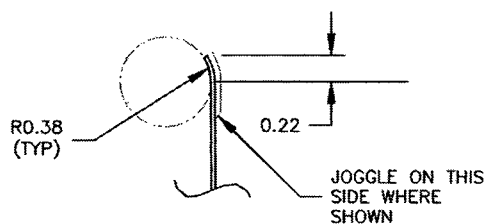
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.128	-		✓	OKm-05
Ø0.191	+0.005/-0.001	.191	-		✓	
1.660	+/-0.010	1.660	-		✓	
0.375	+/-0.010	.375	-		✓	
1.340	+/-0.010	1.340	-		✓	
2.375	+/-0.010	2.375	-		T	
0.375	+/-0.010	.375	-		✓	
25.28	+/-0.030	25.28	-		T	
27.03	+/-0.030	27.03	-		T	
28.10	+/-0.030	28.10	-		T	
1.30	+/-0.030	1.30	-		✓	
2.375	+/-0.010	2.375	-		✓	
8.711	+/-0.010	8.711	-		T	
5.597	+/-0.010	5.597	-		T	
8.57	+/-0.030	8.57	-		T	
1.970	+/-0.010	1.970	-		✓	
7.42	+/-0.030	7.42	-		T	
10.92	+/-0.030	10.92	-		T	
14.75	+/-0.030	14.75	-		T	

<b>Measured by:</b>	AE	<b>Audited by:</b>	DAS 27	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	14.02.09	<b>Date:</b>	14/2/10	<b>Date:</b>	N/A

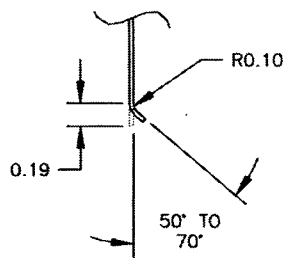
Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	AE



SECTION A-A  
SCALE 1:1  
(TYPICAL, EXCEPT WHERE SHOWN)

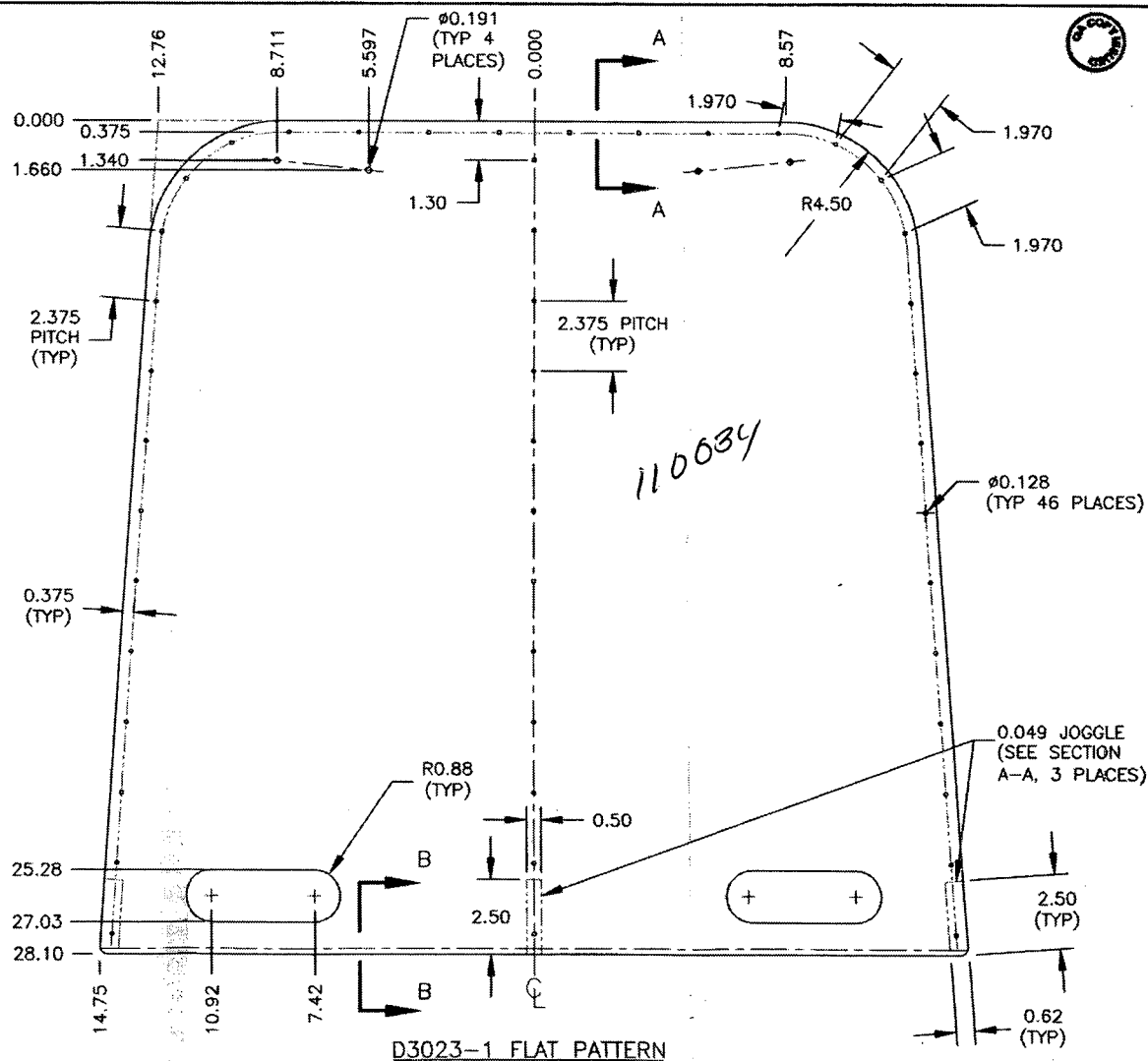


SECTION B-B  
SCALE 1:1  
(BOTTOM EDGE ONLY)



RELEASED  
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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A	01.05.18	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED
DATE	01.05.18	
DRAWING NO. D3023		REV. A SHEET 1 OF 1
TITLE BACK PANEL		SCALE 1:4

**DART**

DART AEROSPACE LTD.  
HAMPSHIRE, ONTARIO, CANADA